

Date: Monday, 1/7/2008 3:39:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEFT ARM WELDMENT
Job Number	: 36649		
Estimate Number	: 12080		
P.O. Number	:	Part Number	: D33543
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D3354 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 36232	Material	:
Written By	:	Due Date	: 1/31/2008
Checked & Approved By	: <u>08.01.8</u>	Qty:	<u>10.</u> Um: Each
Comment	: est rev A 06.01.23 new issue EC Est Rev:B 07-12-10 rev C dwg DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4130NR1250	4130N ROUND BAR
-----	-------------	-----------------



(10)

Comment: Qty: 0.6300 f(s)/Unit Total : ~~25200~~ 6.5000
 AISI 4130 ROUND BAR 1.250" dia. batch: M106961

Y.A 08/02/04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



(10)

Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354
 FOLIO REV: AA
 DWG REV: C

2-DEBURR AS REQUIRED

Y.A/mk 08/02/04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Y.A/mk 08/02/04

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

1-Drill cotter pin hole as per dwg D3354

2-Debur

J.F. 08/02/06 (10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 08/02/06 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AE Date: 08/02/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:39:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 36649

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST485

AS 08/02/07

(X10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/08

Job Completion



mi 2008/2/07

(10)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36649
Description: Wheel Shaft		Part Number:	D3354-3
Inspection Dwg: D3354	Rev: <i>XC</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

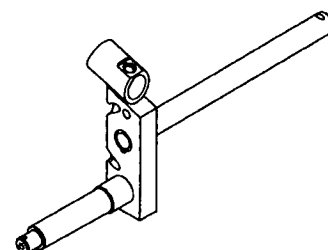
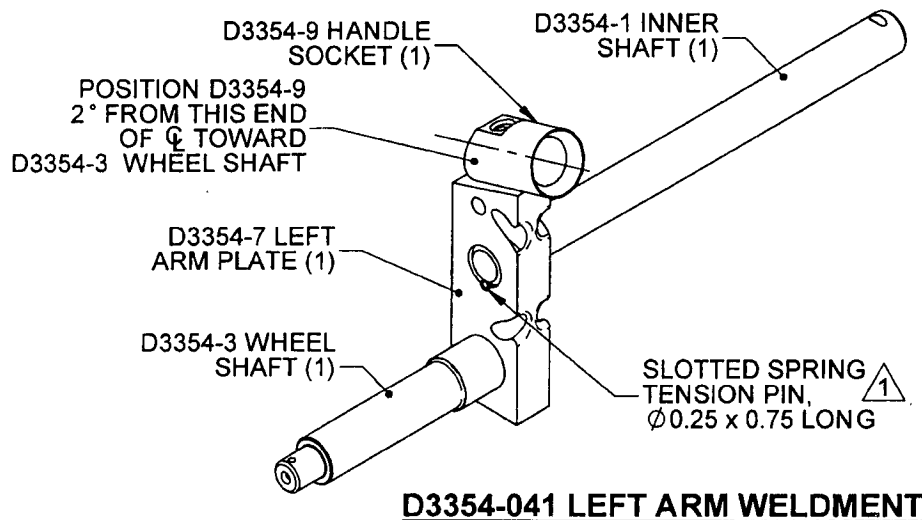
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.04	+/-0.030	7.039	✓			
4.020	+0.010/-0.000	4.025	✓			
0.85	+/-0.030	0.849	✓			
0.06	+/-0.030	0.060	✓			
0.13	+/-0.030	0.135	✓			
Ø1.250	+0.001/-0.004	Ø1.248	✓			
Ø1.103	+0.001/-0.002	Ø1.102	✓			
0.750 Thread	+/-0.010	.745	✓			
0.03 x 45°	+/-0.030 x 0.5°	.035 x 0.5°	✓			
Ø0.152	+0.005/-0.001	Ø.151"	✓			milling
R0.02	+/-0.030	R0.02				
R0.050	+/-0.010	R0.050				
0.660	+/-0.010	.660"	✓			milling
MOW = 2A	min → .7687 max → .7737	.7717	✓			

Measured by: <i>B.A. / gnr / JF</i>	Audited by: <i>SE</i>	Prototype Approval:	N/A
Date: <i>08/02/04</i>	Date: <i>08.02.04</i>	Date:	N/A

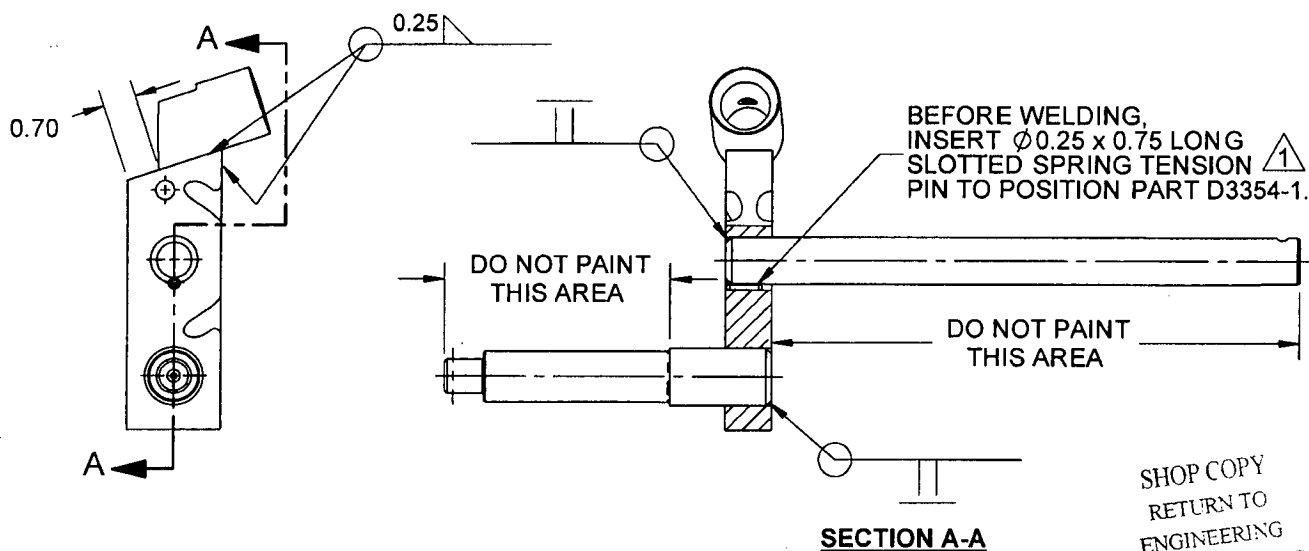
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.04.20	Ø0.152 dimension removed	KJ/JLM <i>JA</i>	<i>JA</i>

DART

DESIGN <i>RF</i>	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LB</i>	APPROVED <i>WJ</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

RELEASED
07.12.07

**D3354-042 MIRROR
ARM WELDMENT**

**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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WORK ORDER
NO. **36649**

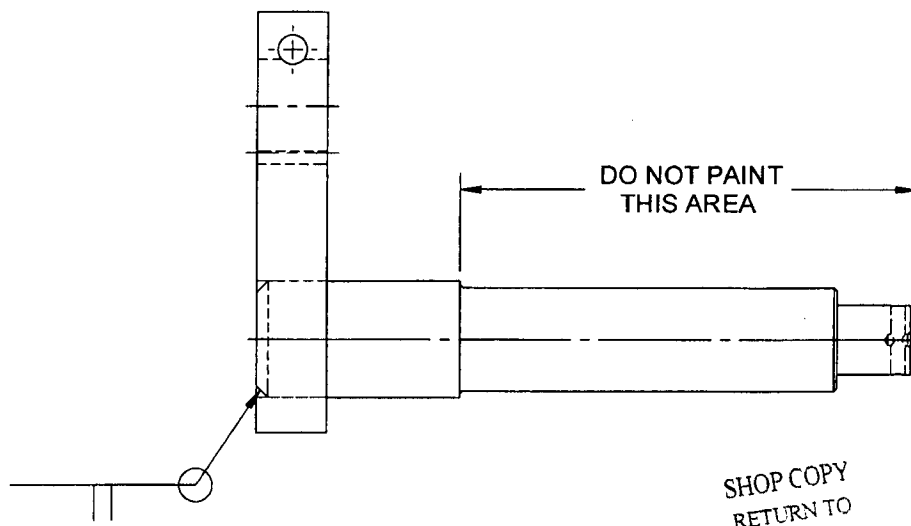
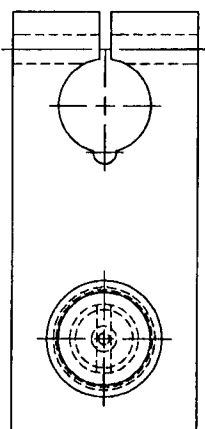
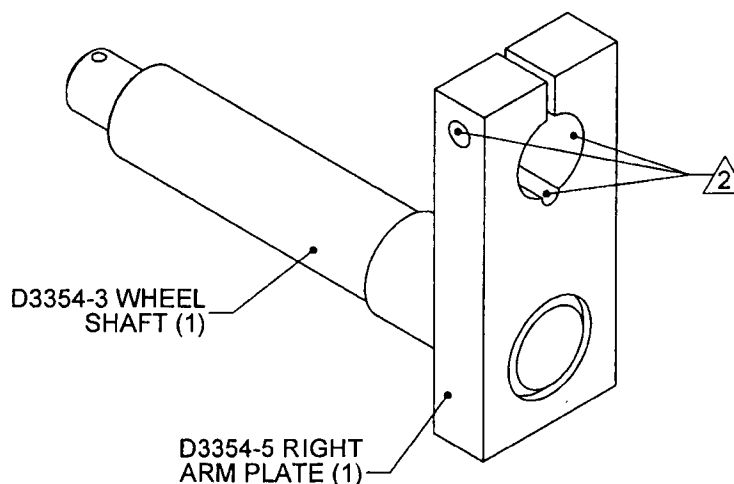
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07/12/07 *WB*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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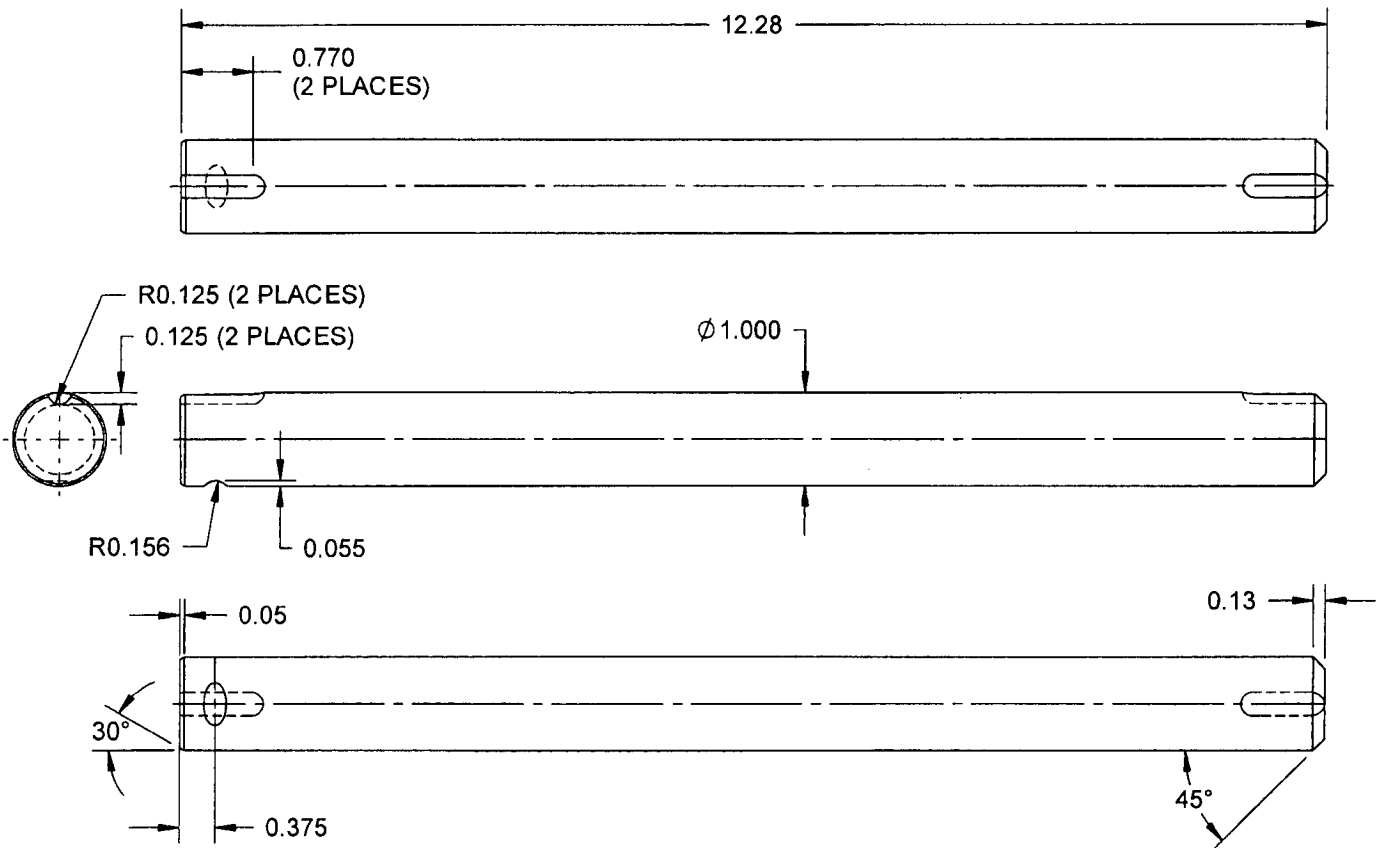
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

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D3354-1 INNER SHAFT

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NOTES:

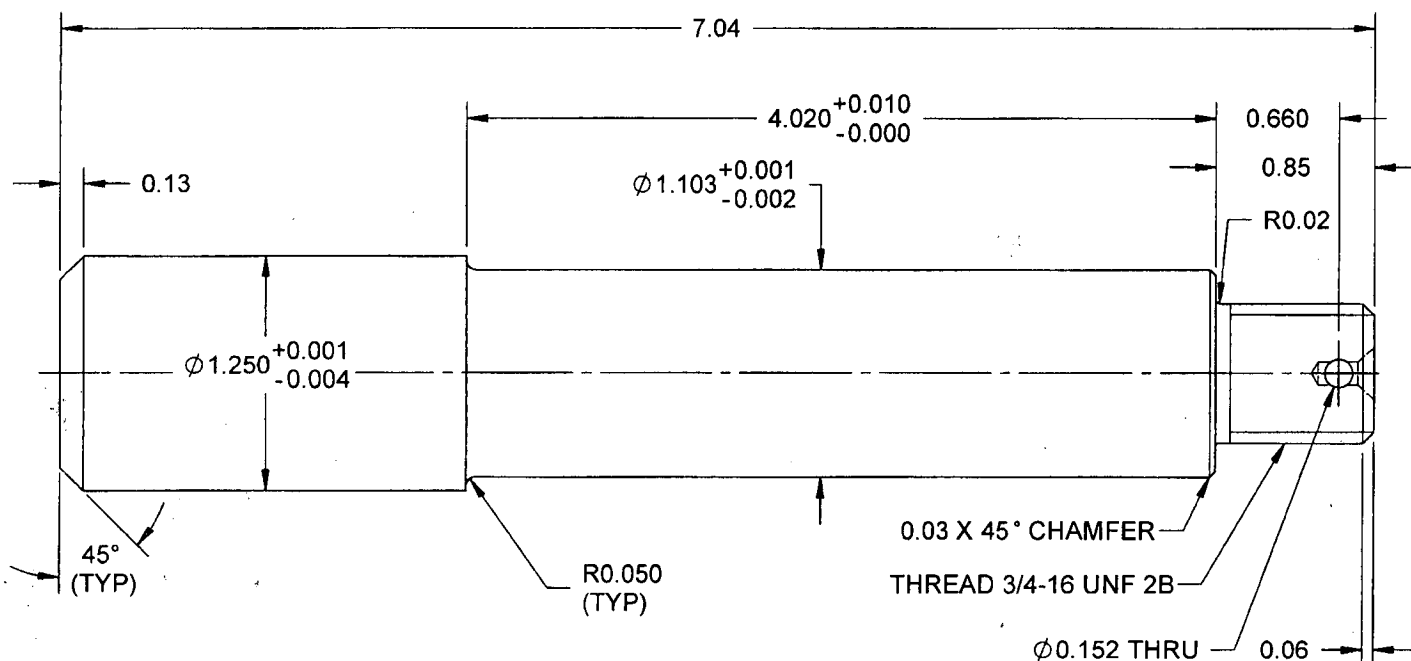
- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>LS</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 4 OF 7
DATE 07.12.06	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
07.12.07 MP**D3354-3 WHEEL SHAFT**

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NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

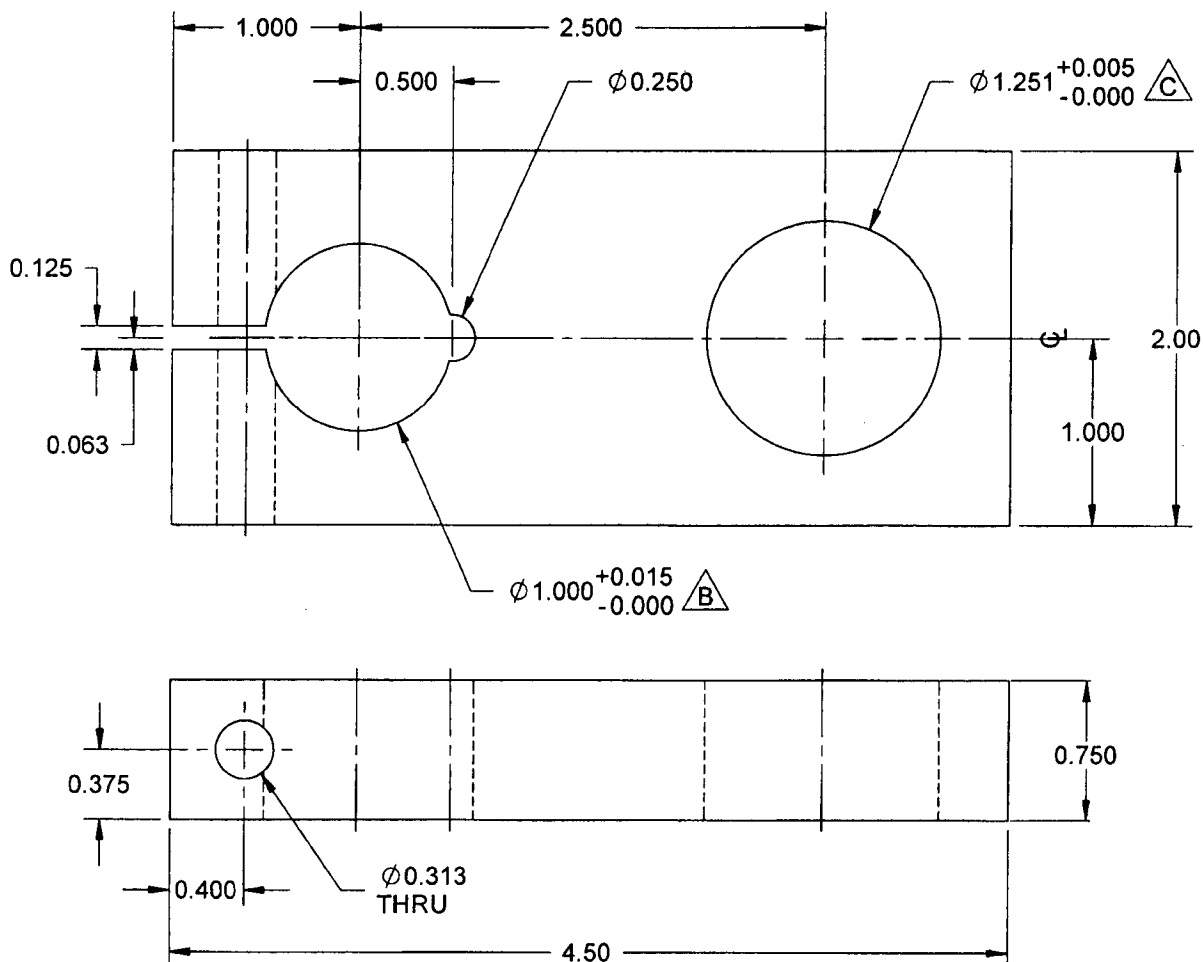
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07/12/07 *[Signature]*



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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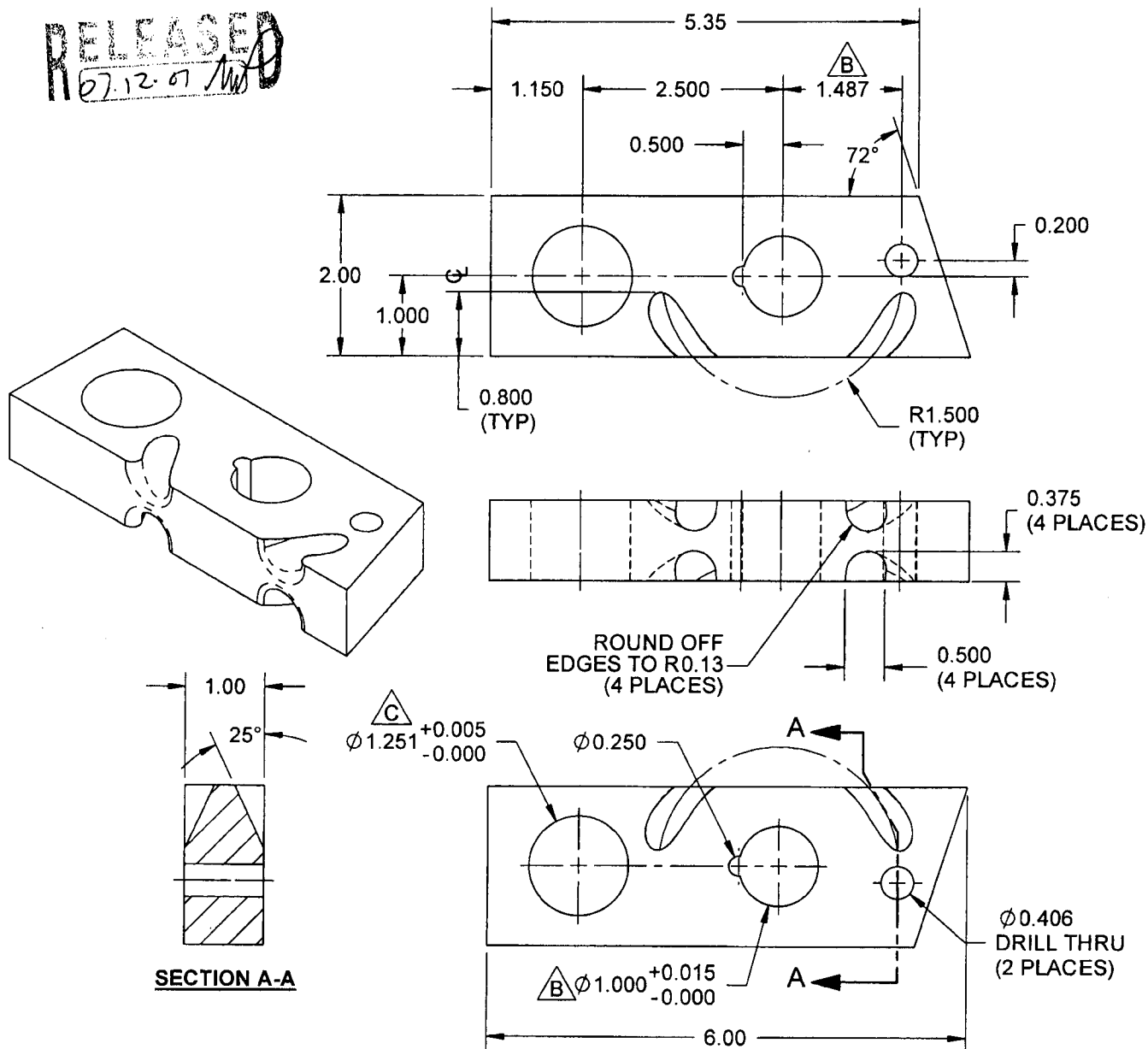
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07.12.07 *[Signature]*



D3354-7 LEFT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

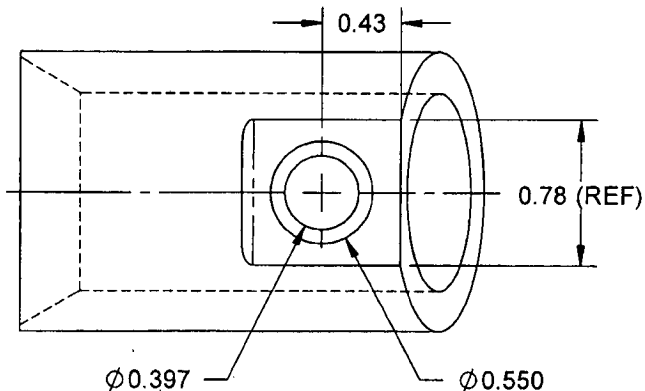
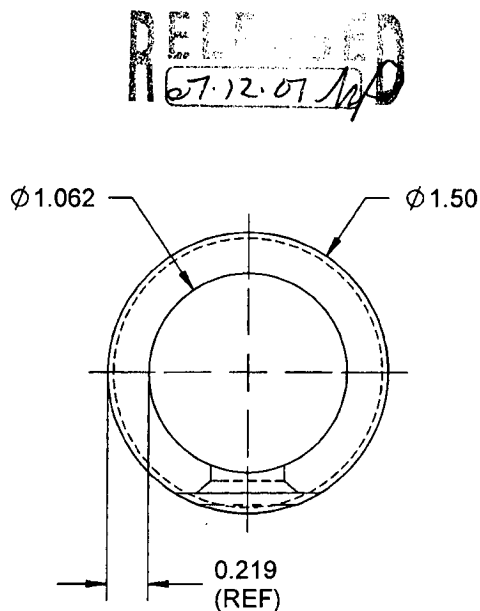
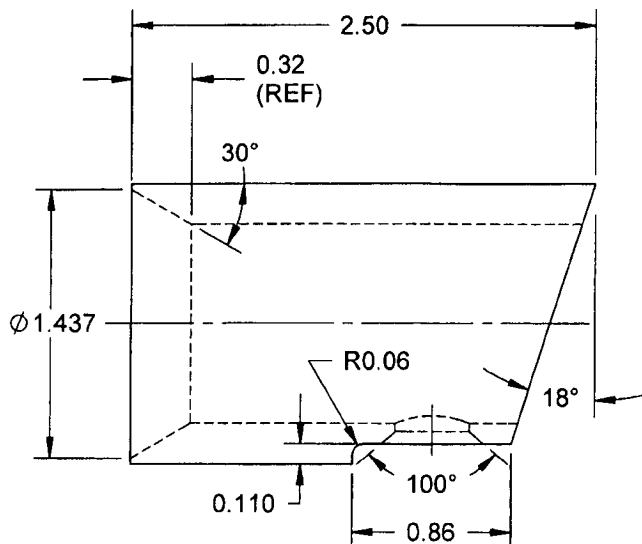
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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